

Celanex® 6400-2

Polybutylene Terephthalate

Celanese Corporation

Message:

40% glass/mineral reinforced polyester, providing warp resistance and improved surface finish.

General Information			
UL YellowCard	E42337-234692	E45575-239405	
Filler / Reinforcement	Glass \mineral, 40% filler by weight		
Features	Bending resistance		
	Excellent appearance		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.66	g/cm³	ISO 1183
Molding Shrinkage - Flow	0.40 - 0.60	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	12000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	110	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	11000	MPa	ISO 178
Flexural Stress (23°C)	180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.8	kJ/m²	ISO 179/1eA
Notched Izod Impact			ISO 180/1A
-30°C	6.0	kJ/m²	ISO 180/1A
23°C	6.0	kJ/m²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	220	°C	ISO 75-2/B
1.8 MPa, not annealed	200	°C	ISO 75-2/A
Vicat Softening Temperature	220	°C	ISO 306/B50
CLTE - Flow	2.5E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	20.0 - 50.0	°C	

Rear Temperature	230 - 250	°C
Middle Temperature	235 - 255	°C
Front Temperature	235 - 255	°C
Nozzle Temperature	250 - 260	°C
Processing (Melt) Temp	235 - 260	°C
Mold Temperature	65.0 - 93.0	°C
Injection Rate	Moderate-Fast	

Injection instructions

Manifold Temperature: 250 to 260°CZone 4 Temperature: 240 to 260°CFeed Temperature: 230 to 250°C

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